

Work Order ID 71584

Wednesday, July 06, 2011 1:25:18 PM



Page 1

Item ID: D3405-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug Assembly

Start Date: 7/6/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 7/20/2011 Req'd Qty: 8.00

Customer:

Reference:

Run Start



Approvals: Process Plan: CZ Date: 11/07/06 Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3405

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3405

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

304 125

11-7-17

9

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

11-7-12

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8 11-7-13

28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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1. The first step in the process is to identify the problem. This involves gathering information about the situation and the people involved.

2. The second step is to analyze the problem. This involves breaking the problem down into smaller parts and identifying the causes.

3. The third step is to develop a plan. This involves deciding on the best way to solve the problem and setting goals.

4. The fourth step is to implement the plan. This involves putting the plan into action and making changes as needed.

5. The fifth step is to evaluate the results. This involves checking to see if the problem has been solved and if the goals have been met.

6. The sixth step is to reflect on the process. This involves thinking about what worked well and what could be improved.

7. The seventh step is to share the results. This involves telling others about what you have learned and how you solved the problem.

8. The eighth step is to continue to learn. This involves staying open to new ideas and ways of solving problems.

9. The ninth step is to be a good team player. This involves working well with others and helping them to solve their problems.

10. The tenth step is to be a good leader. This involves helping others to solve their problems and leading them to success.

(b) (7)(C), (b) (7)(D)

Stop

1. **Author(s)**
2. **Title**
3. **Journal**
4. **Volume**
5. **Issue**
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Cust Item ID:

Author's address: Department of Psychology,
University of California, San Diego,
La Jolla, CA 92037, USA.
E-mail: jacob@ucsd.edu

Customer:

Reference:

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

[illegible]

**Insp.
Stamp**

0.00

Journal Pre-proof

NC BRAKE

0.00

Brake NC

Memo

Brake NC

- 1-Deburr
- 2-Form using DT8204 as per Dwg D3405
- 3- use DT9681 to check if correct forming

SB 1107/14

Q

0.00

QC5- Inspect part completeness to step on W/O

0.00

OC

Memo

Quality Control

8/10/14

5x

0.00

[illegible]

Weld per dwg A/R S.S. rod Batch: M11765-9

0.00

Large Fab

Memo

Large Fab

Weld as per Dwg D3405 use DT8484
Identify as D3405-043

EL 11-7-19

7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71584

Wednesday, July 06, 2011 1:25:18 PM



Page 3

Item ID: D3405-043	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Lug Assembly					
Start Date: 7/6/2011	Start Qty: 8.00		Cust Item ID:		
Required Date: 7/20/2011	Req'd Qty: 8.00		Customer:		
Reference:					

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run	Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00		11-07-19					
170 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		5/10/21					
180 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum m 117745 Memo START TIME: 12:30 OVEN TEMPERATURE: 400° FINISH TIME: 1:00	0.00 0.00							9 of 11-7-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71584

Wednesday, July 06, 2011 1:25:18 PM



Page 4

Item ID: D3405-043	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Lug Assembly					
Start Date: 7/6/2011	Start Qty: 8.00		Cust Item ID:		
Required Date: 7/20/2011	Req'd Qty: 8.00		Customer:		
Reference:					

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run	Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							9 of 11 w/ 102 hrs
200 Packaging Packaging	Identify as per dwg & Stock Location: <i>478</i> Memo	0.00 0.00							11/13/19 <i>22</i>
210 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							11/17/20 <i>MF</i> 11-07-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, July 06, 2011 1:25:16 PM

Page 1

Work Order ID: 71584

Parent Item: D3405-043

Parent Item Name: Lug Assembly



Start Date: 7/6/2011

Required Date: 7/20/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP A 05.09.01 New issue KJ/JLM
IPP B 09.01.28 Rev b dwg EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3404-1		Manufactured	No			100	Each	11.0000	1	8			
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GHW Lug

70664X9

Location	Loc Qty	Loc Code
WA	8	
69883	8	
WA030	3	
67127	3	

M304S11GA		Purchased	No			150	sf	102.0000	0.154	1.296842	1.5		
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304/316 0.125 Sheet

Location	Loc Qty	Loc Code
MAT020	102	
117494	102	

117494

9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

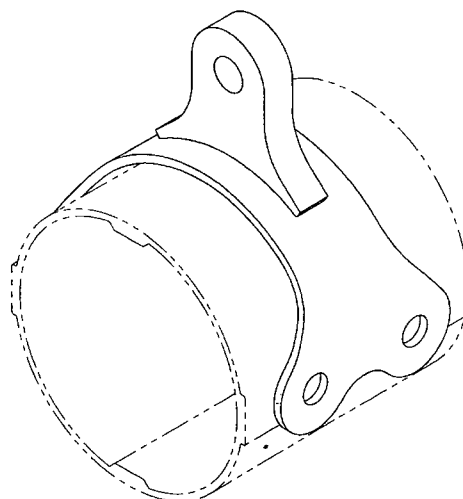
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

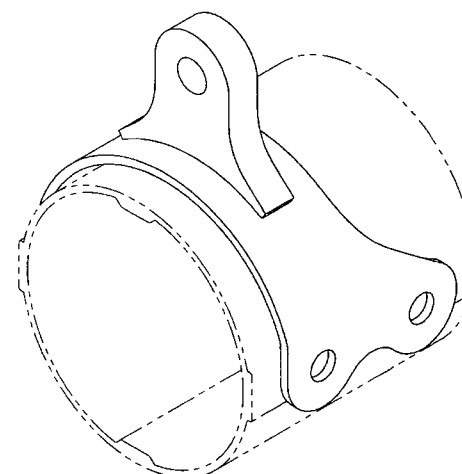
NOTE: Date & initial all entries

ITEM No.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D3405-041	LUG ASSEMBLY
2		X	D3405-043	LUG ASSEMBLY
11	1	1	D3404-1	GHW LUG
12	1		D3405-1	GHW BRACKET
13		1	D3405-3	GHW BRACKET

△B



D3405-041 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)



D3405-043 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)

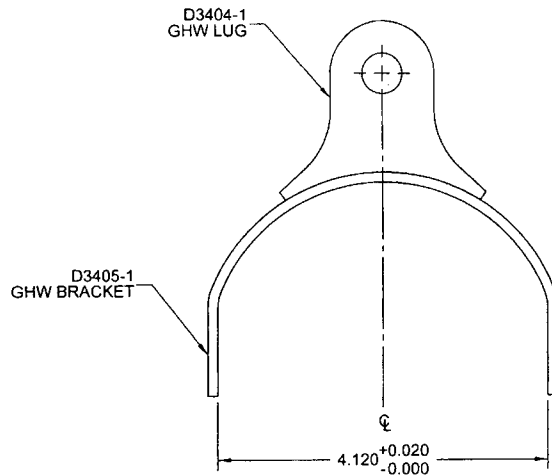
TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71589
CX1110710p

RELEASED
08/12/18 M.P.

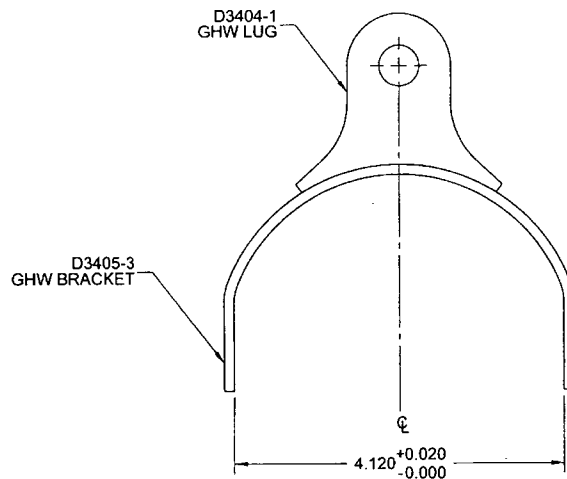
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER
IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -041, 0.85 lbs
-043, 0.87 lbs

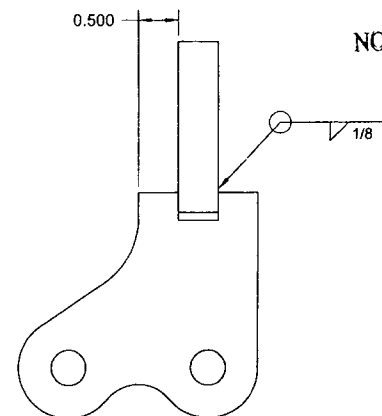
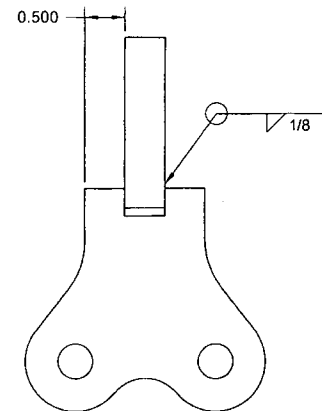
B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERNS FOR -1 & -3 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). SHEETS 3 & 4 ZONE A6 4.120 DIM WAS 4.100.		AJS	08.09.19
A	NEW ISSUE		PH	05.03.08
REV.	DESCRIPTION		BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D3405		SHEET 1 OF 4
APPROVED		TITLE	SCALE	
DE APPR.		GHW LUG ASSEMBLY	NTS	
DATE	08.09.19	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		



D3405-041 LUG ASSEMBLY







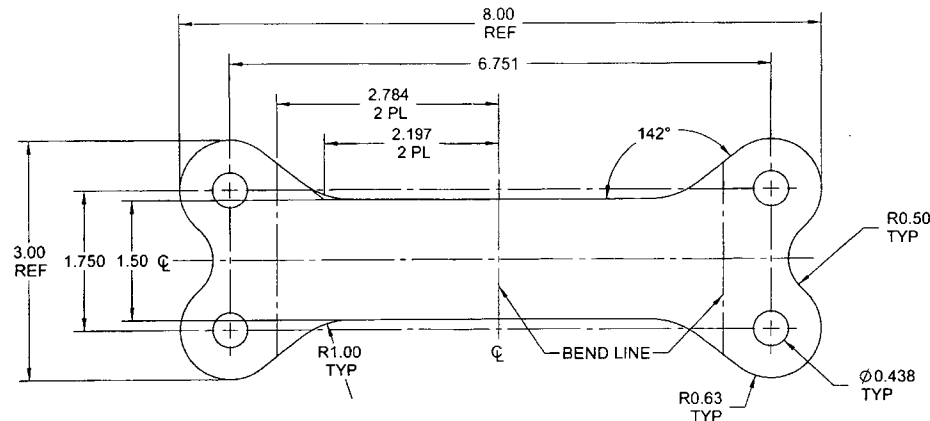
D3405-043 LUG ASSEMBLY



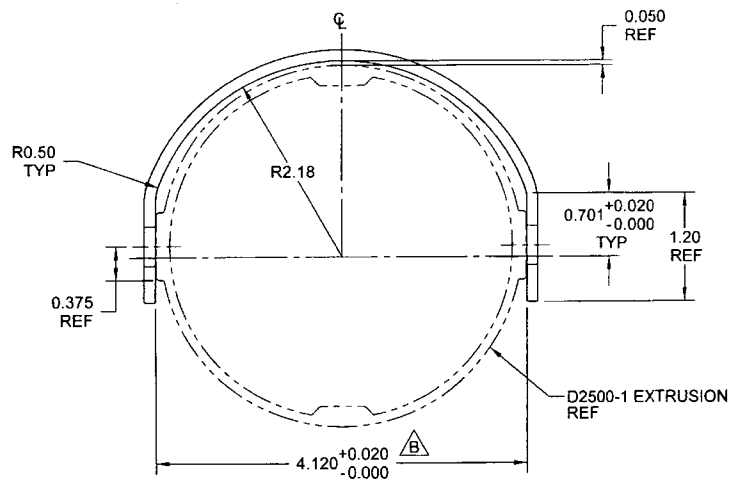
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71584

RELEASED
06/12/18 MJP

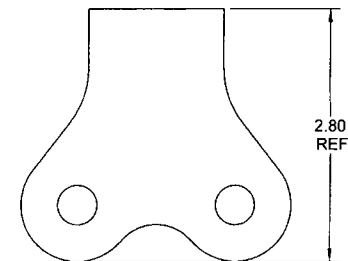
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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D3405	SHEET 2 OF 4
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D3405-1F GHW BRACKET FLAT PATTERN



D3405-1 GHW BRACKET
(MAKE FROM D3405-1F)







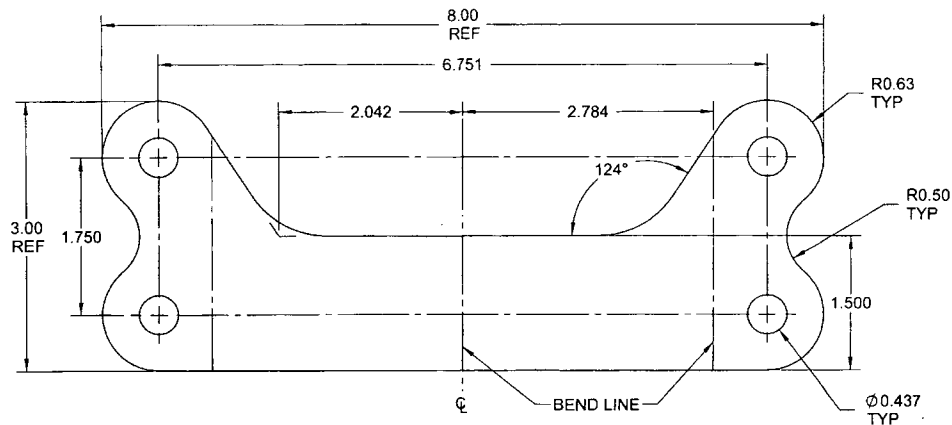
SIDE VIEW FOR REF ONLY

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RETURN TO
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WITHOUT NOTICE
WORK ORDER
NO. 71584

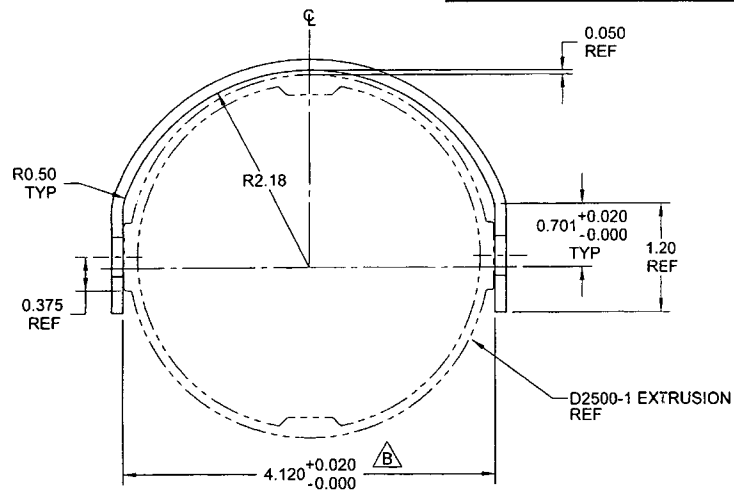
RELEASED
07-08/12/18

- NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: N/A

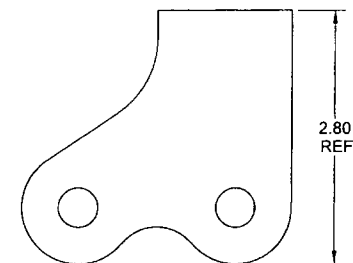
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D3405	REV. B
MFG. APPR.			SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG ASSEMBLY	NTS
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D3405-3F GHW BRACKET FLAT PATTERN



D3405-3 GHW BRACKET
(MAKE FROM D3405-3F)



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71584

RELEASED
08/12/19

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D3405	REV. B
MFG. APPR.			SHEET 4 OF 4
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